

Work Order ID 52831

October 15, 2009 11:06:58 AM



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Item ID: D3929-041
Revision ID: A
Item Name: Gusset Assembly

Accept



Setup Start



Stop



Start Date: 15/10/2009 Start Qty: 6.00
Required Date: 22/10/2009 Req'd Qty: 6.00



Cust Item ID:
Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: RL Date: 09-10-15 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3929	Rev A

100 0.00



Waterjet
FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3929
Dwg Rev: A
Prog Rev: A

2-Deburr if necessary

0.00

B 9-10-15

110 0.00



QC
Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

B 9-10-15

10

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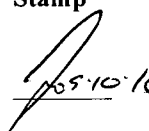

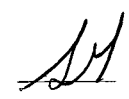


Required Date: 22/10/2009 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				10			 09/10/16
130  Packaging Packaging	Pick Kit Memo	0.00 0.00							 09/10/20 (10x)
140  Large Fab Large Fab	 Memo Weld bushings D3907-1 as per dwg D3929 316L rod batch: <u>M109213</u>	0.00 0.00							 09/10/20 (10x)

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							PD 09.10.23 (10)
160  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							201 2) 507/10/23 (10) f
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>Gusset</u> Memo	0.00 0.00							PD 09.10.23 (10)

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Reference:


Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

09.10.27

PR 09-10-23

Picklist Print

Page 1

October 15, 2009 11:07:03 AM

Work Order ID: 52831



Parent Item: D3929-041RevA



Parent Item Name: Gusset Assembly

Start Date: 15/10/2009

Required Date: 22/10/2009

Comments.

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA 		Purchased	No			100	sf	157.7312	2.8421	4.7368		
304/316 0.125 Sheet												

189-10-16

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

157.7311979

111018

29.7311979

112663

128

111018

D3907-1RevA

Manufactured No

130

Each

44.0000

12.0000



Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

44

50944

4

51475

40

20x

09/10/20

8

7

6

5

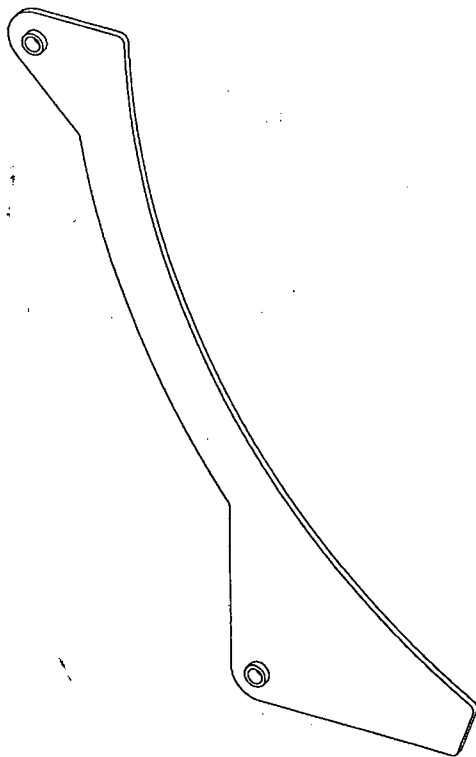
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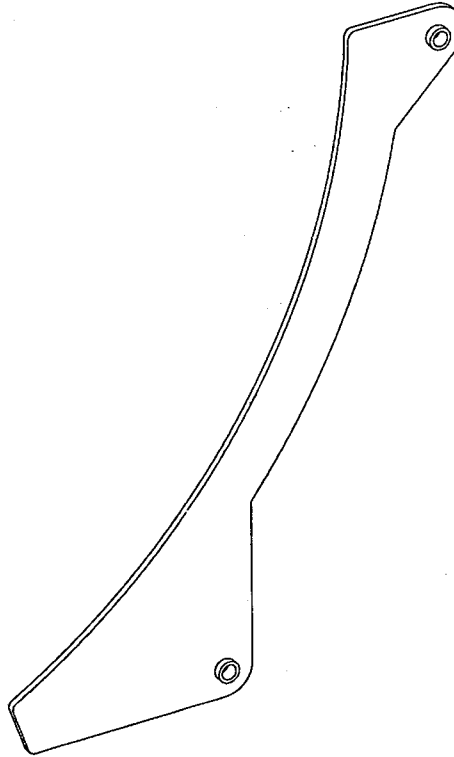
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ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52831
BP 09-10-15

RELEASED
3/10/12 MB

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs EACH
- 8) WELDING: PER DART QSI 004

A	NEW ISSUE		MB	09.04.03
REV.		DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	09.04.03			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3929** REV. A
SHEET 1 OF 3

TITLE **GUSSET ASSEMBLY** SCALE **NTS**

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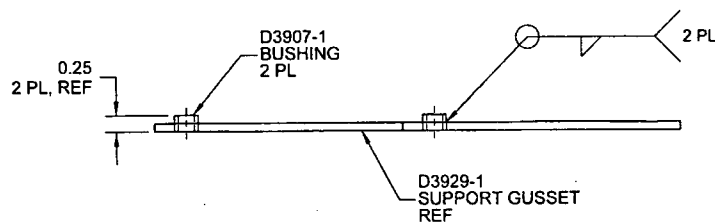
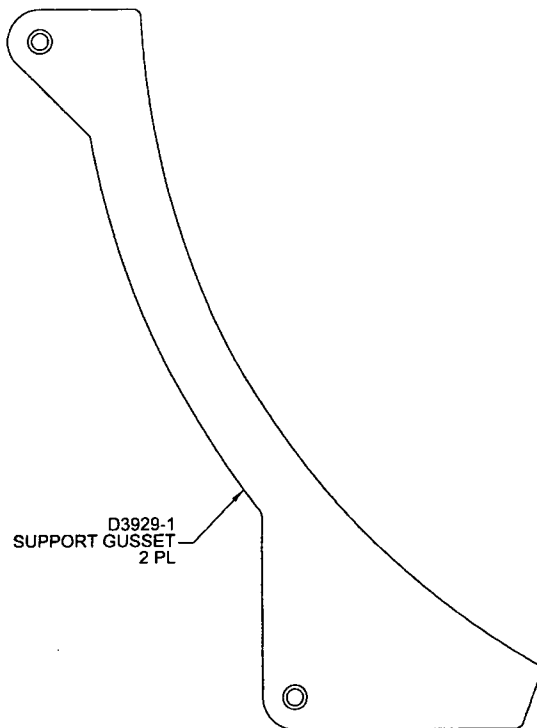
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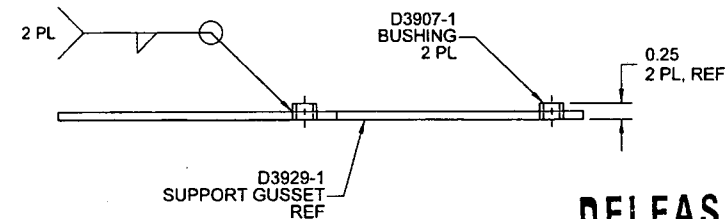
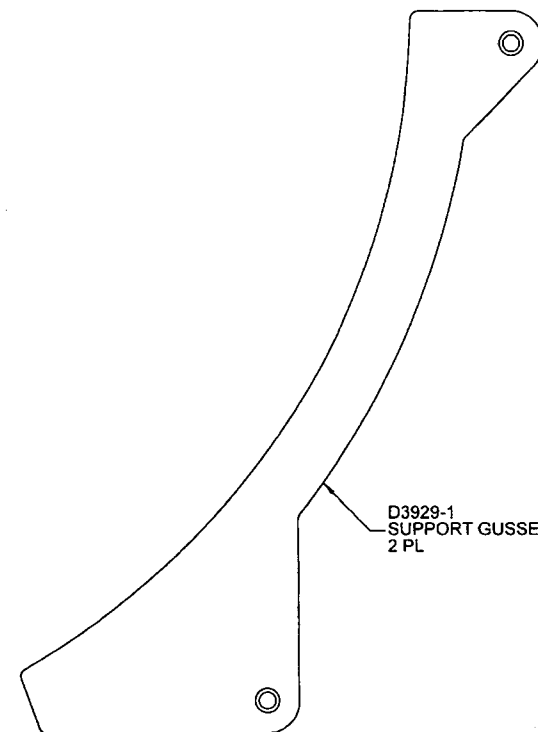
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D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

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